

*SPLIT*

**Dart Aerospace Ltd.**

Date: Wednesday, 16/04/2008 3:53:38 PM  
User: Julie Lecocq

# Process Sheet

|   |  |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services  | Drawing Name : WEARPLATE               |
| Job Number : 38646 <i>2</i>   |  |
| Estimate Number : 10437   |  |
| P.O. Number :   | Part Number : D33191                   |
| This Issue : 16/04/2008 S.O. No. :  | Drawing Number : D3319 REV, B          |
| Prsht Rev. : NC   | Project Number : N/A                   |
| First Issue : 1/1 Type : SMALL /MED FAB   | Drawing Revision : B                   |
| Previous Run : 38112  | Material :                             |
| Written By :  | Due Date : 25/04/2008 Qty: 12 Um: Each |
| Checked & Approved By : <i>JD 08-4-16</i>   |  |
| Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC<br>Est Rev:C Now on Waterjet 06-10-26 JLM |  |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :                |
|---------|-----------------------|------------------------------|
| 1.0     | M1010S18GA            | 1010/1025/A21/6aA SHEET .048 |



Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s)  
1010/1025/A21/6aA SHEET .048  
Batch: *106348 B 8-4-18*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
1-Cut as per Dwg D3319  
Dwg Rev: *B* *IB 8-4-18*  
Prog Rev: *B*  
2-Deburr if necessary *IB 8-4-18*



|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*02/04/18 (12)*

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr if necessary

*Done & JSC 022*  
*02/04/18*

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

2- Form flat on press using DT8776 block

JB 08/04/21

(12)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/04/21 (x12)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

M106390

08-04-25

08-04-

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/04/20 (x1)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/20 (x1)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

08-04-2

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/04/29 (x1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

08/04/29 (x1)

Form: process

Date: Wednesday, 16/04/2008 3:53:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38646

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

and Stock

Location: ST496

JS 08/04/29 (XU)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WOP-04.29



|                               |               |                     |         |
|-------------------------------|---------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>     |               | <b>Work Order:</b>  | 38646   |
| <b>Description:</b> Wearplate |               | <b>Part Number:</b> | D3319-1 |
| <b>Inspection Dwg:</b> D3319  | <b>Rev:</b> B | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance                | Actual Dimension | Accept  | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|---------|--------|----------------------|----------|
| 4.984             | +/-0.010                 | 4.983            | *       |        |                      |          |
| 1.600             | +/-0.010                 | 1.603            | *       |        |                      |          |
| 2.660             | +/-0.010                 | 2.666            | *       |        |                      |          |
| 3.190             | +/-0.010                 | 3.197            | *       |        |                      |          |
| 3.563             | +/-0.010                 | 3.564            | *       |        |                      |          |
| 4.712             | +/-0.010                 | 4.709            | *       |        |                      |          |
| 0.60              | +/-0.030                 | .605             | *       |        |                      |          |
| 10.576            | +/-0.010                 | 10.576           | *       |        |                      |          |
| 11.942            | +/-0.010                 | 11.943           | *       |        |                      |          |
| 18.09             | +/-0.030                 | 18.09            | *       |        |                      |          |
| Ø0.316 x 0.546    | +0.006/-0.001 x +/-0.010 | .318             | x .546* |        |                      |          |
| Ø0.316 x 0.670    | +0.006/-0.001 x +/-0.010 | .316             | x .672* |        |                      |          |
| Ø0.190            | +0.005/-0.001            | .197             | *       |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |
|                   |                          |                  |         |        |                      |          |

|                     |        |
|---------------------|--------|
| <b>Measured by:</b> | IB     |
| <b>Date:</b>        | 8-4-19 |

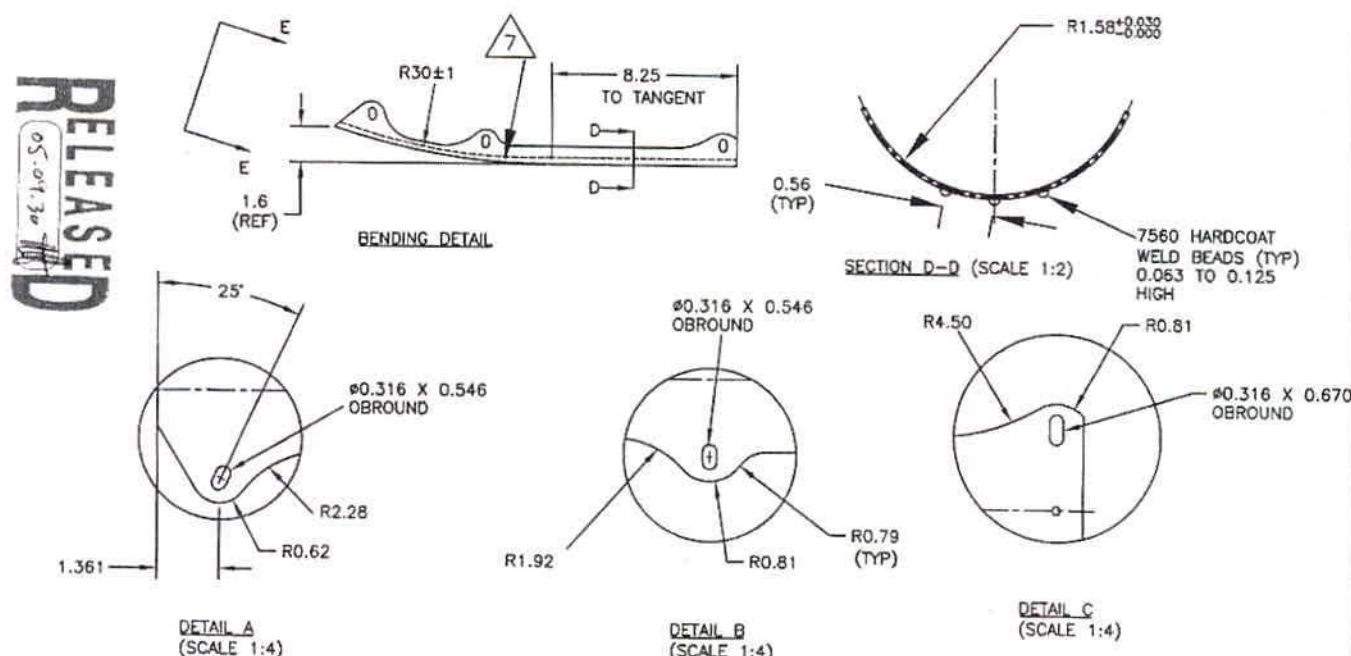
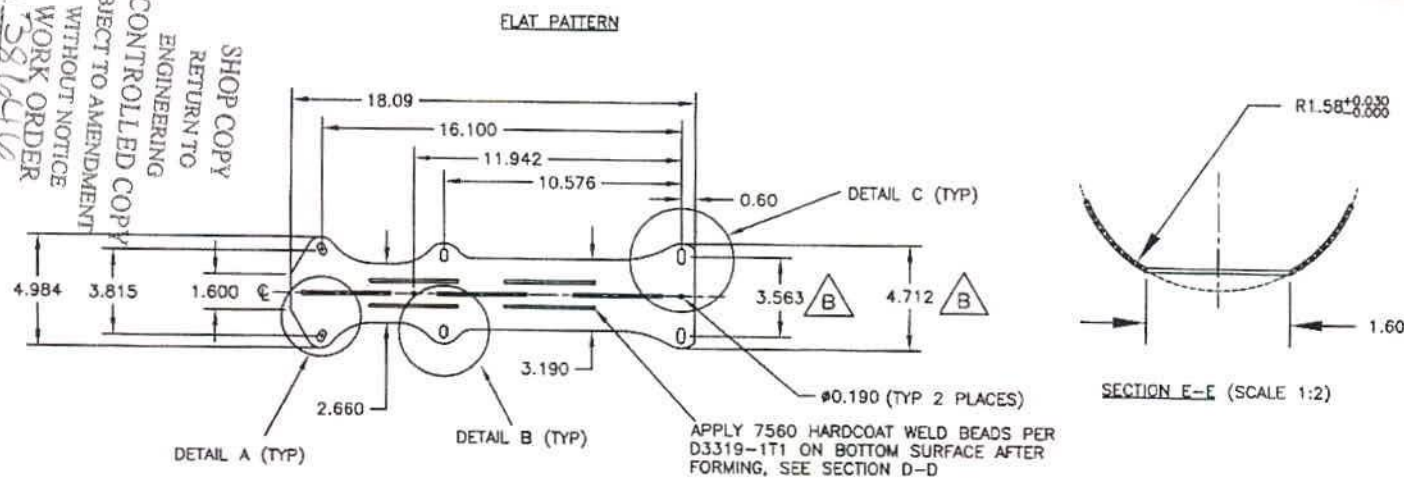
|                    |             |
|--------------------|-------------|
| <b>Audited by:</b> | [Signature] |
| <b>Date:</b>       | 08/04/19    |

|                            |     |
|----------------------------|-----|
| <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by         | Approved    |
|-----|----------|-----------|--------------------|-------------|
| A   | 07.05.31 | New Issue | KJ/JLM [Signature] | [Signature] |

**DART**

| DESIGN   | DRAWN BY  | DART AEROSPACE LTD                 |
|----------|-----------|------------------------------------|
| P41      | P41       | HAWKESBURY, ONTARIO, CANADA        |
| CHECKED  | APPROVED  | DRAWING NO.                        |
|          |           | D3319                              |
| DATE     | TITLE     | REV. B                             |
| 05.06.06 | WEARPLATE | SHEET 1 OF 5                       |
| A        | 04.09.24  | NEW ISSUE                          |
| B        | 05.06.06  | WIDEN HOLES, REDUCE WIDTH -3/-5/-7 |
|          |           | SCALE 1:8                          |



- D3319-1 WEARPLATE
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) PART IS SYMMETRICAL ABOUT CENTERLINE
  - 5) ALL DIMENSIONS IN INCHES
  - 6) WELD PER DART QSI 004
  - 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-16"

RELEASED  
05.01.30